

Work Order ID 86026

June-19-12 4:05:35 PM

86026

Page 1

Item ID: D4149-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Aft

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	C

100 0.00

100

Small Fab

Memo

Small Fab

1- Assemble as per dwg

110 QC5- Inspect part completeness to step on W/O

110

QC

Memo

Quality Control

120 Identify as per dwg & Stock Location: *460* 0.00

120

Packaging

Memo

Packaging

SMB
12-8-13

DAS
16
12/08/13

4K

12/08/08

4

12/08

12/08

12/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/08	#100	Found Qty of D3910-1 with multiple nicks/scratches in the Power Cont. R. in inspection handling	DAS 16 12/08/08	Remove from Assembly. D3910-1 was pulled from U/A S. Stock is for replacement work on other w/o.	12/08/08		DAS 16 12/08/08	DAS 16 12/08/08
				w/o # _____				

NOTE: Date & initial all entries

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Page 2

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4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS 12/08/14

R1208/14

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Picklist Print

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Page 1

Work Order ID: 86026

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

86026

D4149-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	1,319.000	4	8			
MS21043-3									**				
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				ST301		1247							
				118077		2							
				118614		51							
				118686		30							
				119758		20							
				121255		188							
				121708		956							
MS21043-4		Purchased	No			100	Each	1,094.000	1	12			
MS21043-4									**				
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		40							
				104603		40							
				ST301		1054							
				119546		115							
				121162		439							
				121652		500							

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-19-12 4:05:39 PM

Page 2

Work Order ID: 86026

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

86026

D4149-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3910-1 Manufactured No

100 Each

31.0000

1

4

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

31

81474

2

81573

29

D4091-1 Manufactured No

100 Each

66.0000

1

4

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

66

81168

26

81575

40

D4149-1 Manufactured No

100 Each

55.0000

2

8

D4149-1

Crosstube Lug Plate, Aft

**

Location

Loc Qty

Loc Code

ST102

55

82121

3

83472

12

85751

40

D4149-3 Manufactured No

100 Each

13.0000

1

4

D4149-3

Spacer

**

Location

Loc Qty

Loc Code

ST102

13

78046

1

84194

12

Handwritten notes and signatures:
 - Top: *EP 12/08/07*
 - Middle: *B85619(4x)*
 - Bottom: *EP 12/08/07*
 - Bottom: *B85750(4x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 86026

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

86026

D4149-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D4149-5

Manufactured No

100 Each

20.0000 1 4

D4149-5

Eyebolt Stud

**

EP 12/08/07

Location

Loc Qty

Loc Code

ST102

20

83888

7

84195

13

B85783
(4x)

AN3C12A

Purchased No

100 Each

225.0000 2 8

AN3C12A

Bolts

**

EP 12/08/07

Location

Loc Qty

Loc Code

GA

38

120449

38

ST351

187

117514

4

118112

5

118451

22

119510

1

120423

51

121259

4

121584

50

121689

50

M122416 (8x)

AN4C13A

Purchased No

100 Each

44.0000 3 12

AN4C13A

BOLT

**

EP 12/08/07

Location

Loc Qty

Loc Code

ST357

44

120187

1

121827

43

M122416
(12x)

June-19-12 4:05:39 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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June-19-12 4:05:39 PM

Page 4

Work Order ID: 86026

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

86026

D4149-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS20615-4M18

Purchased

No

100

Each

33.0000

3

12

MS20615-4M18

Rivet

**

EP 12/08/07

Location

Loc Qty

Loc Code

322

3

121349

3

ST322

30

121444

30

NAS1149C0332R

Purchased

No

100

Each

9,782.000

4

16

NAS1149C0332R

Washer

**

M122452
EP 12/08/07

Location

Loc Qty

Loc Code

297

9782

122063

9782

NAS1149C0432R

Purchased

No

100

Each

3,718.000

6

24

NAS1149C0432R

Washer

**

EP 12/08/07

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2648

121255

2648

24

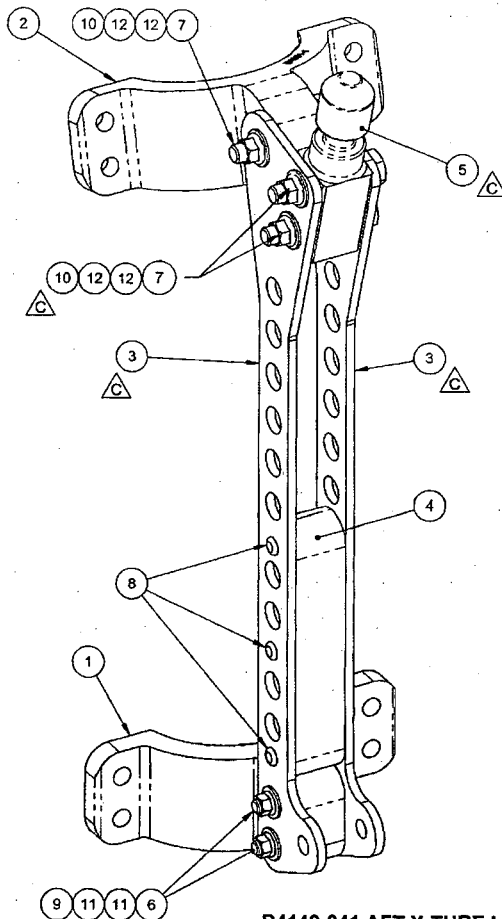
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86026 *mw*

12/06/20

RELEASED
2011-02-23
W

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C6-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZD D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZD D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZD D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZD D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

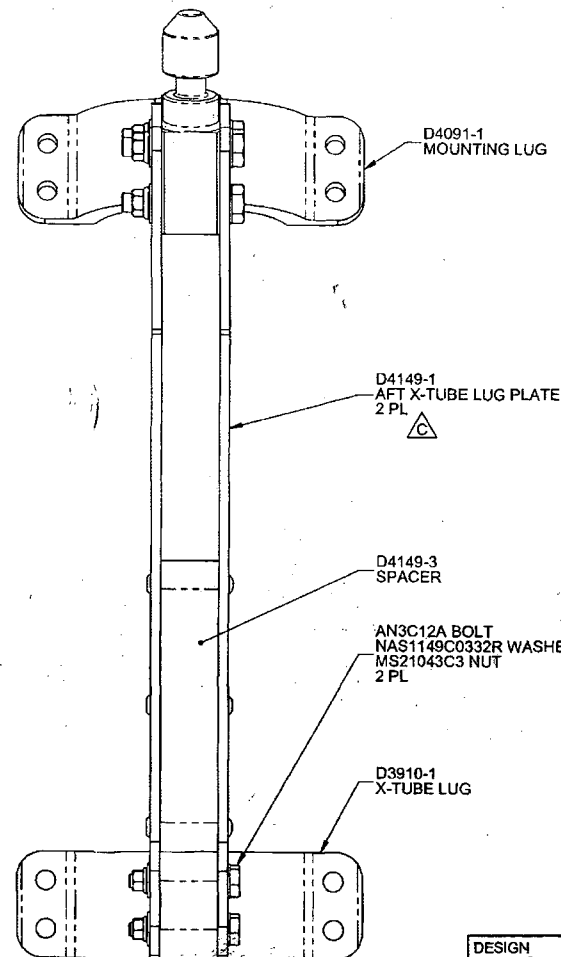
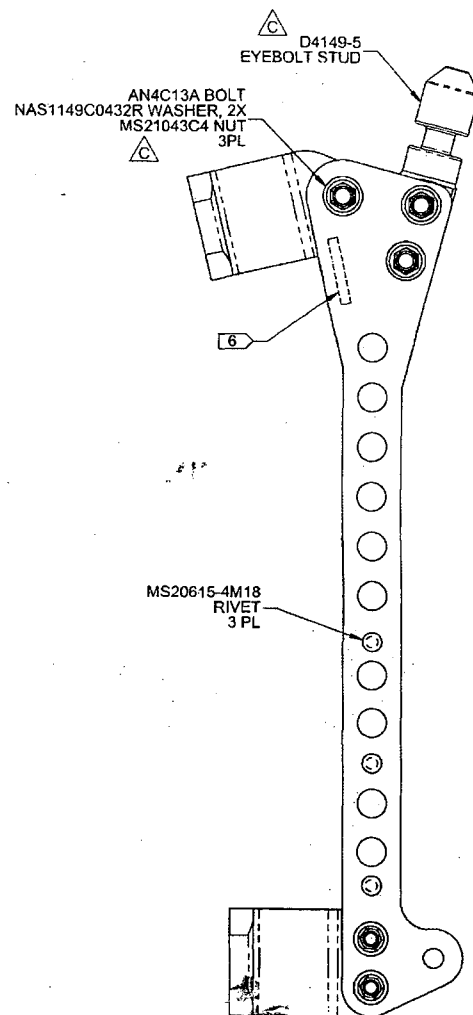
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: 11 NCR: Yes No DQA: 1 Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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